TG-S62 TRUSTARC™

TIG welding rod and wire

Features: ▪ Suitable for 550 to 590MPa tensile strength steel

Classification: AWS A5.28 ER80S-G

Shielding gas: Ar
Identification color: 1st White
Polarity: DCEN

Packaging data

	Tube		
ϕ mm	**kg**	**Length mm**	**g/piece**
1.6	5	1,000	16
2.0	5	1,000	25
2.4	5	1,000	35
3.2	5	1,000	63
Volume mm	40W, 35H, 1015L		

Composition (wire mass%)

	Typical	Guaranty [a]
C	0.08	0.10
Si	0.74	0.30~0.85
Mn	1.38	1.15~1.65
P	0.007	0.020
S	0.006	0.020
Ni	0.03	0.60
Mo	0.52	0.25~0.65
Cu	0.16	0.50

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	Rod
1.6	60~220
2.0	80~240
2.4	100~260
3.2	150~300

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	540	530	420min.
TS (MPa)	660	640	552min.
El on 4d (%)	28	26	18min.
IV -20℃ (J)	180	98	27min.
PWHT (℃xh)	AW	620x1	AW & 620±15x1